

Date: Wednesday, 5/23/2007 3:45:20 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPAD
Job Number : 32510	
Estimate Number : 10700	
P.O. Number : <i>N/A</i>	Part Number : D34291
This Issue : 5/23/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3429 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : 31037	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 6/15/2007 Qty: 20 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est: A 05.10.04 New Issue KJ/EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S16GA	1010/1025/A21/6aA SHEET
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Comment: Qty.: 0.1512 sf(s)/Unit Total : 3.0240 sf(s)
 1010/1025/A21/6aA steel sheet 0.063" thick
 Batch: *104421* *ml 07 06 08* (20)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3429
 Dwg Rev: *A* *ml 07 06 08* (20)
 Prog Rev: *A*
 2-Deburr if necessary *SAD 07/06/20*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Deburr if necessary
 Form on Brake as per Dwg D3429 using Jigs DT8261 and DT8326. Identify as D3429-1
 Form Joggle as per Dwg D3429 on brake using Jig DT8158

mf 07-06-20 (20)
SB 07/06/20 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 01/06/27

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

J/En 07/06/21 *cont'd* *(20)*

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description

A/R560Hardcoat

Batch

M103SS1

Weld hardcoat as per Dwg D3429

FC 07/06/23 *(20)*

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/06/25 *(20)*

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/06/25 *(20)*

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 104846

BR/M 07-06-28 *(20)*

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 07/06/29 *(20)*

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-16

m-l 07/06/29

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/29 *(20)*

Job Completion



U 07/06/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

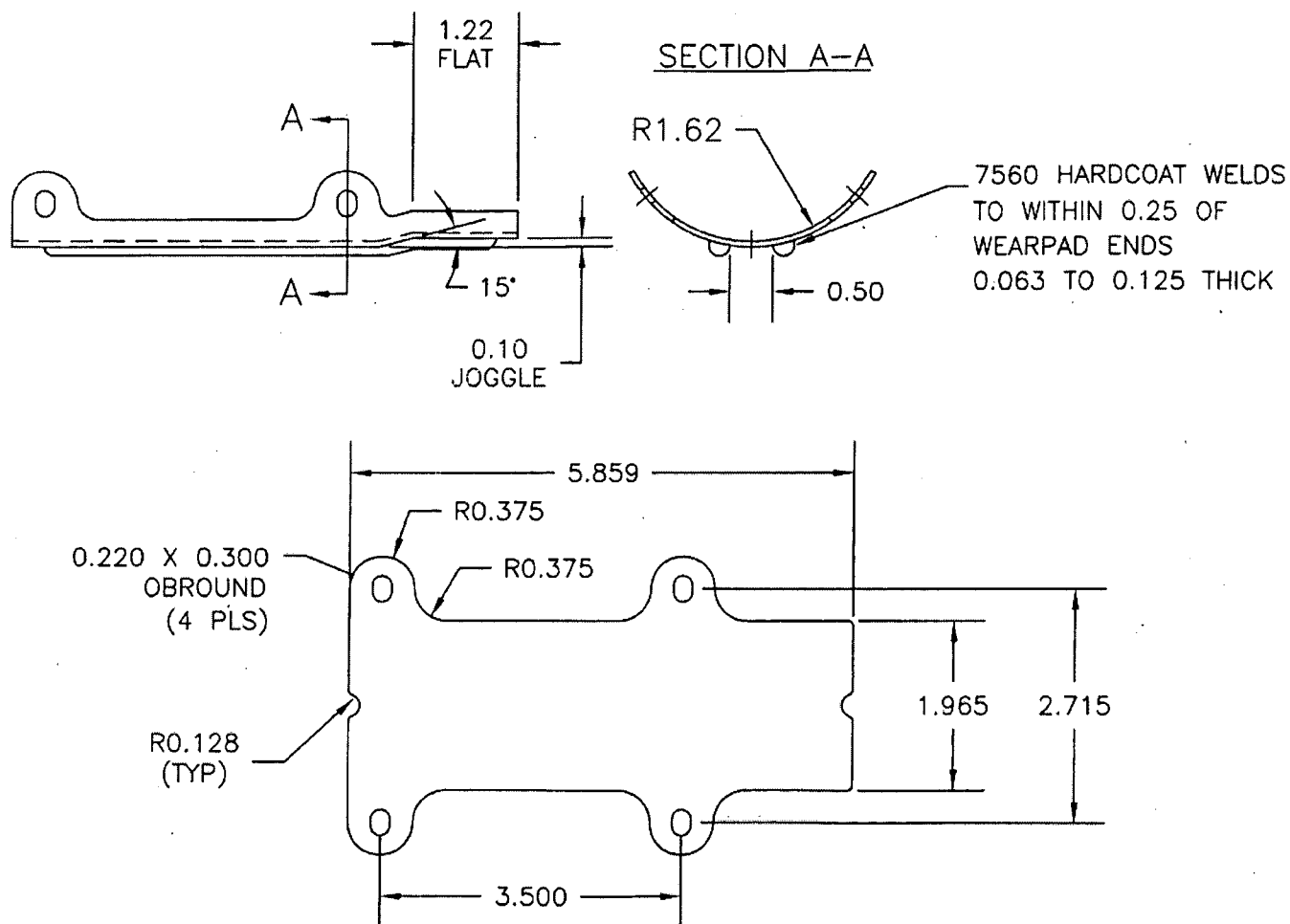
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3429	REV. A SHEET 1 OF 1
DATE 05.04.18		TITLE WEARPAD	SCALE 1:2
A	05.04.18	NEW ISSUE	

RELEASED
05.09.06**D3429-1 WEARPAD**

- 1) BREAK ALL SHARP CORNERS 0.063 MAX
- 2) MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 IN THICK)
- 3) FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) WELD PER DART QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32510

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DART AEROSPACE LTD		Work Order: 32510
Description: War pad		Part Number: D3429-1
Inspection Dwg: D3429 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 0.220x0.300	+/-0.010	0.220x0.300	✓		VEN	
B 5.859	+/-0.010	5.869	✓		VEN	
C 3.500	+/-0.010	3.503	✓		VEN	
D 1.965	+/-0.010	1.970	✓		VEN	
E 2.715	+/-0.010	2.711	✓		VEN	
F R0.128	+/-0.010	R0.128	✓		R-G	
G R0.375	+/-0.010	R0.375	✓		R-G	
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: <i>mm. mm</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 07 06 08	Date: 07-06-11	Date:	N/A
Rev	Date	Change	Revised by
		New Issue	KJ/RF
			Approved